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(54) Title: INKJET PRINTING OF PEARLESCENT AND METALLIC COLOURS

(57) Abstract: A method of inkjet printing a colour image including a metallic or pearlescent colour comprising the steps of applying on part of an ink receiver a layer containing a pearlescent or metallic pigment having a volume mean particle size of at least 3.0 µm as measured by laser diffraction; and inkjet printing on part of the layer containing the pearlescent or metallic pigment a layer with a white inkjet ink containing a white pigment having a average particle size between 250 and 400 nm as measured by differential centrifugal sedimentation.



WO 2016/071173 A1

Description**Inkjet Printing of Pearlescent and Metallic Colours****Technical Field**

[0001] The present invention relates to inkjet printing a pearlescent or metallic effect on an ink receiver, such as silver and gold coloured lines on packaging.

Background Art

[0002] Printing systems, such as offset and flexography, are being increasingly replaced by inkjet printing systems for industrial applications, due to their flexibility in use, e.g. variable data printing, and due to their enhanced reliability allowing their incorporation into production lines. Radiation curable inkjet inks are particularly preferred because high quality colour images can be printed on non-absorbing ink-receivers, such as plastic materials.

[0003] These high quality colour images are generally printed using a CMYK inkjet ink set. However for some applications, it is desired to print pearlescent and metallic colours. For example, in packaging applications often silver and gold colours are used to give a product a certain luxury aspect or to make products stand out on the shelf. Silver and gold colours are produced in offset and flexography using special pigments having a particle size distribution of about 5 to 50 μm as well as a high aspect ratio. Often mica platelets coated with a metal oxide are used for these special pigments.

[0004] Inkjet print heads generally have nozzles with a nozzle diameter of about 25 μm in order to print fine image details. For reliable inkjet printing, as a rule of thumb, the pigments in an inkjet ink should have a particle size which is at least 50 times, preferably at least 100 times smaller than the nozzle diameter. As the special pigments currently available for printing silver and gold colours tend to have particle sizes which are equal or larger than the nozzle diameter, they are not suitable for inkjet printing.

[0005] Some companies are trying to minimize the particle size of these special pigments. **WO 2011/000491** (ECKART) discloses pearlescent pigments having a d_{90} value of 3.5 μm , while **US 2010194836** (ECKART) discloses

aluminium effect pigments having a d50-value of a volume averaged particle size distribution curve of 1 μm to 15 μm with an average thickness h50 of 15 to 150 nm. However practical tests with a commercially available metallic inkjet ink of ECKART GmbH and inkjet inks containing the above described pigments show that only an inferior metallic gloss (greyish) is achievable, and also that reliable inkjet printing is not guaranteed.

- [0006] The observation that a silver colour becomes greyish is caused by decreasing the particle size and the aspect ratio to a size so that it can pass through the nozzle of inkjet print heads. One solution would be to design inkjet print heads with large nozzle diameters, however then only coarse and not fine image details, like thin silver or gold lines, can be printed.
- [0007] Another active field of research is that of metallic conductive inkjet inks as disclosed by e.g. **EP 2087490 A** (HP), **EP 2074055 A** (LG CHEM) and **US 2010171064** (SAMSUNG) . These inkjet inks are all based on the same basic principle, i.e. inkjet printing silver nano-particles of about 10 to 50 nm followed by sintering under heat to form solid, conductive patterns of metal. These metallic conductive inkjet inks are largely irrelevant for graphic applications, such as inkjet printing silver colours on packaging materials. First of all, the sintering takes place at temperatures of more than 150 degrees Celsius which would render many common packaging materials unsuitable as ink receiving substrates in view of their thermal stability. Secondly, many sintered metal patterns do not exhibit (sufficient) metallic gloss or brilliance. And thirdly, using real silver for obtaining silver colours on a packaging would be an uneconomical solution in view of the cost of the raw material.
- [0008] Some new concepts using two-component or multi-component metal nano-particles of less than 20 nm are evaluated to lower sintering temperatures, making the range of ink receivers somewhat broader. For example, **US 2011169888** (ELECTRONICS FOR IMAGING) discloses that thermal curing can then take place at temperatures of about 80 to 100°C. However, such inkjet compositions generally consist of metal nano-particles and solvents that evaporate. Any organic solids in these inks

drastically increase sintering temperatures. As a result poor adhesion is obtained, thus necessitating often the application of an extra undercoat coating.

[0009] Therefore, there exists still a need in inkjet printing to be able to print variable data and fine image details exhibiting excellent pearlescent and metallic colours on a wide range of ink receivers, including thermo sensitive ink receivers.

Summary of invention

[0010] In order to overcome the problems described above, preferred embodiments of the present invention have been realised with an inkjet printing method as defined by **claim 1**.

[0011] In retrospect, the solution of the above problem appears to be very simple. However, surprisingly in the market such a method could not be found. Nevertheless it possesses many advantages, such as variable data printing using state-of-the-art inks that produce pearlescent and metallic colours.

[0012] Further objects of the invention will become apparent from the description hereinafter.

Definitions

[0013] The term "alkyl" means all variants possible for each number of carbon atoms in the alkyl group i.e. methyl, ethyl, for three carbon atoms: n-propyl and isopropyl; for four carbon atoms: n-butyl, isobutyl and tertiary-butyl; for five carbon atoms: n-pentyl, 1,1-dimethyl-propyl, 2,2-dimethylpropyl and 2-methyl-butyl, etc.

[0014] Unless otherwise specified a substituted or unsubstituted alkyl group is preferably a C₁ to C₆-alkyl group.

[0015] Unless otherwise specified a substituted or unsubstituted alkenyl group is preferably a C₁ to C₆-alkenyl group.

[0016] Unless otherwise specified a substituted or unsubstituted alkynyl group is preferably a C₁ to C₆-alkynyl group.

[0017] Unless otherwise specified a substituted or unsubstituted aralkyl group is preferably a phenyl or naphthyl group including one, two, three or more C₁ to C₆-alkyl groups.

- [0018] Unless otherwise specified a substituted or unsubstituted alkaryl group is preferably a C₇ to C₂₀-alkyl group including a phenyl group or naphthyl group.
- [0019] Unless otherwise specified a substituted or unsubstituted aryl group is preferably a phenyl group or naphthyl group
- [0020] Unless otherwise specified a substituted or unsubstituted heteroaryl group is preferably a five- or six-membered ring substituted by one, two or three oxygen atoms, nitrogen atoms, sulphur atoms, selenium atoms or combinations thereof.
- [0021] The term “substituted”, in e.g. substituted alkyl group means that the alkyl group may be substituted by other atoms than the atoms normally present in such a group, i.e. carbon and hydrogen. For example, a substituted alkyl group may include a halogen atom or a thiol group. An unsubstituted alkyl group contains only carbon and hydrogen atoms
- [0022] Unless otherwise specified a substituted alkyl group, a substituted alkenyl group, a substituted alkynyl group, a substituted aralkyl group, a substituted alkaryl group, a substituted aryl and a substituted heteroaryl group are preferably substituted by one or more constituents selected from the group consisting of methyl, ethyl, n-propyl, isopropyl, n-butyl, isobutyl and tertiary-butyl, ester group, amide group, ether group, thioether group, ketone group, aldehyde group, sulfoxide group, sulfone group, sulfonate ester group, sulphonamide group, -Cl, -Br, -I, -OH, -SH, -CN and -NO₂.
- [0023] The term “image” includes text, numbers, graphics, logos, photos, barcodes, QR codes, and the like. An image can be defined in 1 or more colours, such an image is referred to as a colour image.
- [0024] The term “pearlescent” means an iridescent luster resembling that of pearl or mother-of-pearl, i.e. nacreous.
- [0025] The term “metallic colour” means a colour with a metallic sheen or luster, such as silver and gold, but includes other colours like e.g. metallic blue as used for a lacquer to paint cars.

Inkjet Printing Methods

- [0026] The method of inkjet printing a colour image including a metallic or pearlescent colour according to the present invention comprises the steps

of: applying on part of an ink receiver a layer containing a pearlescent or metallic pigment having a volume mean particle size of at least 3.0 μm as measured by laser diffraction; and inkjet printing on part of the layer containing the pearlescent or metallic pigment a layer with a white inkjet ink containing a white pigment having a average particle size between 250 and 400 nm as measured by differential centrifugal sedimentation.

[0027] As already pointed out above, the layer containing a pearlescent or metallic pigment having a volume mean particle size of at least 3.0 μm can be applied at room temperature and does not require any high temperature sintering. Furthermore, the composition containing a pearlescent or metallic pigment having a volume mean particle size of at least 3.0 μm may contain other organic solids for ensuring good adhesion on a wide range of ink receivers. For example, the inclusion of a polyvinylbutyral polymer in such a solvent based composition allows even adhesion to glass.

[0028] Pigments having large average particle sizes which normally would not result in reliable inkjet printing due to failing nozzles that are clogged, can now be used to maximize the luster or brilliance of the layer containing the pearlescent or metallic pigment. Preferably, pearlescent or metallic pigments having a volume mean particle size of 5 μm to 50 μm , more preferably 10 μm to 35 μm , as measured by laser diffraction are used.

[0029] By using a large average particle size for the white pigment in the white inkjet ink, an opaque layer is obtained that masks the layer containing the pearlescent or metallic pigment. Preferably the white pigment has an average particle size between 250 and 400 nm, more preferably between 270 and 350 nm. An average particle size smaller than 250 nm results in insufficient opaqueness, unless undesirable thick layers of white inkjet ink are applied. At average particle sizes above 400 nm inkjet printing reliability deteriorates rapidly.

[0030] Another advantage is that by having an opaque white layer that 'transparent' colour pigmented inkjet inks, such as those of a CMYK inkjet ink set, can be used resulting in a large colour gamut with brilliant colours. In such 'transparent' colour pigmented inkjet inks, it was found that an

average particle size of no more than 230 nm should be used. By printing a 'transparent' colour pigmented inkjet ink (hereinafter simply colour inkjet ink) on the layer containing the metallic pigment which was not covered by the white inkjet ink, a colour is obtained having a metallic effect. By applying this principle it was found that a single silver coloured metallic pigment layer suffices to deliver both a silver colour when not overprinted and a gold colour when overprinted by a yellow inkjet ink at a limited surface coverage, preferably at a surface coverage between 10% and 45%, more preferably between 15% and 35%. In analogue printing techniques, such as offset and flexography, two compositions are used for producing both a silver colour and a gold colour. So the inkjet printing method of the current invention also allows for a simplification of the image formation process.

- [0031] In a preferred embodiment, the inkjet printing method includes a further step of inkjet printing a layer of a colour inkjet ink containing a colour pigment having an average particle size of no more than 230 nm on part of the layer containing a pearlescent or metallic pigment, wherein the average particle size is measured by dynamic light scattering.
- [0032] The inkjet printing method is preferably a UV curable inkjet printing method as such a method allows obtaining high image quality by UV curing the ink directly after landing on the layer containing the metallic pigment.
- [0033] In a preferred embodiment, the white inkjet ink is a UV curable white inkjet ink. More preferably also the colour inkjet ink is an UV curable colour inkjet ink.
- [0034] There is no real restriction on how the layer containing a pearlescent or metallic pigment is applied. However, for reasons of productivity and flexibility, the layer containing a pearlescent or metallic pigment is preferably applied by a method selected from the group consisting of coating techniques, flexographic printing, valve-jet printing, tampon printing, gravure printing, screen printing and offset printing, but most preferably by flexographic printing or valve-jet printing. Suitable coating techniques include knife coating, extrusion coating, slide hopper coating and curtain coating.

- [0035] In a preferred embodiment, the layer containing a pearlescent or metallic pigment is applied by a printing technique selected from the group consisting of a valve jet print head, a piezo needle print head and a through flow print head. The through flow print head is preferably a piezoelectric through flow print head
- [0036] Piezoelectric inkjet printing is based on the movement of a piezoelectric ceramic transducer when a voltage is applied thereto. The application of a voltage changes the shape of the piezoelectric ceramic transducer in the print head creating a void, which is then filled with ink. When the voltage is again removed, the ceramic expands to its original shape, ejecting a drop of ink from the print head.
- [0037] A suitable piezoelectric print head for jetting droplets containing pearlescent or metallic pigments is the through flow piezoelectric print head Xaar™ 001 of XAAR, which jets droplets having a volume of up to 200 nL typically at a viscosity between 5 and 35 mPa.s and allows particles having a particle size of 25 µm to be present.
- [0038] Another preferred print head for jetting droplets containing pearlescent or metallic pigments is a so-called valvejet print head. A valvejet print head is also called coil package or micro valves or a dispensing module of micro valves. The droplet forming means in a valvejet print head controls a micro valve in the valvejet print head by actuating electromagnetically to close or to open the micro valve so that the liquid flows through the liquid channel. Valvejet print heads preferably have a maximum dispensing frequency up to 3000 Hz. The way to incorporate valvejet print heads into an inkjet printing device is well-known to the skilled person. For example, **US 2012105522** (MATTHEWS RESOURCES) discloses a valvejet printer including a solenoid coil and a plunger rod having a magnetically susceptible shank. Suitable commercial valvejet print heads are HSV400 and HSV800 from ZIMMER, Printos™ P16 from VideoJet and the coil packages of micro valve SMLD 300's from FRITZ GYGER™. A nozzle plate of a valvejet print head is often called a faceplate and is preferably made from stainless steel.

- [0039] A piezo needle print head is also suitable for jetting the metallic and pearlescent pigments. Such print heads have been used, for example, in a digital textile printer by ZIMMER at ITMA2003, where the technology was called FlatJet™ technology. The functioning of a piezo needle print head is described e.g. in **US 6460980** (HEGEDUS ET AL) .
- [0040] In order to achieve very fine image details, like thin silver lines having a width of no more than 0.5 mm, the inkjet printing of the white inkjet ink is preferably performed by one or more print heads having nozzles with a nozzle diameter of no more than 35 µm, preferably no more than 25 µm.
- [0041] The white and colour inkjet inks are jetted by print heads preferably having a nozzle diameter smaller than 35 µm for jetting droplets of up to 30 pL. These print heads are preferably piezoelectric print heads, more preferably through flow piezoelectric print heads.
- [0042] Suitable commercial piezoelectric print heads for jetting ink droplets having a volume of up to 30 pL are available from many sources such as XAAR, KYOCERA, RICOH and TOSHIBA TEC.
- [0043] In order to achieve very fine image details, like thin silver lines having a width of no more than 0.5 mm, the inkjet printing of the white inkjet ink is preferably performed by one or more print heads having nozzles with a nozzle diameter of no more than 35 µm, preferably no more than 25 µm.

Pearlescent and Metallic Pigments

- [0044] The method of inkjet printing according to the present invention includes the step of applying on part of an ink receiver a layer containing a pearlescent or metallic pigment. Such pigments are well-known to a person skilled in the art of preparing inks containing pearlescent or metallic pigments. These pigments are also readily commercially available, and generally have a volume mean particle size of at least 3.0 µm.
- [0045] In a preferred embodiment, the pearlescent or metallic pigment has an average particle size between 5.0 and 50.0 µm.
- [0046] The pigments may be included in aqueous, solvent based and UV curable inks, such as flexo inks.
- [0047] There is no real restriction on the type of pearlescent or metallic pigment.

- [0048] A wide range of these pigments and their preparation is described in literature. For example, **US 5972098** (MERCK) discloses the preparation of titanate-containing pearlescent pigments.
- [0049] Suitable commercially available metallic pigments are Xirallic grades from MERCK, which are aluminum oxide platelets covered with titanium oxide showing a strong glitter effect with a distinct shimmering behaviour.
- [0050] Also suitable are mica platelets coated with titanium dioxide and/or iron oxide. Commercially available pearlescent pigments are available as Mearlin™ grades from BASF and Symic™ grades from ECKART.
- [0051] The metallic pigment may mimic the following metals: silver, bronze, brass, platinum, steel, chromium, titanium and Britannia metal. The metallic pigment preferably has a silver colour. In the latter case, it can be combined with one or more colour pigment inkjet inks to mimic the above mentioned metals, thereby simplifying the printing process by enlarging the number of accessible metal colours by a single metal ink.
- [0052] Preferred metallic pigments include plate-like crystals of bismuth oxychloride that have a silver-white and transparent appearance. Such metallic pigments are available as Mearlite™ luster pigments from BASF.
- [0053] The metallic pigments include also vacuum-metallized aluminum pigments (VMPs) such as the Metasheen™ grades from BASF. The latter are composed of lamellar, non-leafing aluminum flakes dispersed in a variety of solvents.
- [0054] Other suitable commercial vacuum metallized pigments include the Starbrite™ Reveal VMF pigments from SILBERLINE, generally having a particle size D_{50} of 8 to 12 μm .

White Inkjet Inks

- [0055] In a preferred embodiment of the inkjet printing method according to the present invention, the white inkjet ink is a UV curable white inkjet ink. Contrary to aqueous or solvent based inkjet inks, it was found that a layer of a UV curable white inkjet ink adheres to a wide range of different layers containing a pearlescent or metallic pigment.
- [0056] The pigment for the white inkjet ink is preferably a pigment with a refractive index greater than 1.60, preferably greater than 2.00, more

preferably greater than 2.50 and most preferably greater than 2.60. The white pigments may be employed singly or in combination.

- [0057] In a particularly preferred embodiment, titanium dioxide is used in the white inkjet ink. Titanium oxide occurs in the crystalline forms of anatase type, rutile type and brookite type. The anatase type has a relatively low density and is easily ground into fine particles, while the rutile type has a relatively high refractive index, exhibiting a high covering power. Either one of these is usable in this invention. It is preferred to make the most possible use of characteristics and to make selections according to the use thereof. The use of the anatase type having a low density and a small particle size can achieve superior dispersion stability, ink storage stability and ejectability. At least two different crystalline forms may be used in combination. The combined use of the anatase type and the rutile type which exhibits a high colouring power can reduce the total amount of titanium oxide, leading to improved storage stability and ejection performance of ink.
- [0058] For surface treatment of the titanium oxide, an aqueous treatment or a gas phase treatment may be applied, and an alumina-silica treating agent may be employed. Untreated-, alumina treated- or alumina-silica treated-titanium oxide are employable.
- [0059] The determination of the average particle diameter is best performed by using a disc centrifuge (DCS), such as the CPS24000 of CPS instruments.
- [0060] The pigment is preferably used in a pigment dispersion used for preparing inkjet inks in an amount of 10 to 55 wt%, more preferably of 15 to 50 wt% based on the total weight of the pigment dispersion. In a UV curable white inkjet ink, the pigment is preferably present in an amount of 7 to 30 wt%, preferably 10 to 20 wt% based on the total weight of the inkjet ink.

Colour Inkjet Inks

- [0061] The method of inkjet printing a colour image including a metallic or pearlescent colour according to the present invention preferably uses also one or more colour inkjet inks in addition to the white inkjet ink.
- [0062] In a more preferred embodiment, a set of colour inkjet inks is used. The colour inkjet ink set preferably includes at least a white inkjet (W), a cyan

inkjet ink (C), a magenta inkjet ink (M), and a yellow inkjet ink (Y), and more preferably also a black inkjet ink. The inkjet ink set is preferably a UV curable CMYKW inkjet ink set.

- [0063] The CMYKW inkjet ink set may also be extended with extra inks such as red, green, blue, and/or orange to further enlarge the colour gamut of the colour image. The inkjet ink set may also be extended by the combination of the full density inkjet inks with light density inkjet inks. The combination of dark and light colour inks and/or black and grey inks improves the image quality by a lowered graininess.
- [0064] The inkjet ink set may also contain at least a white inkjet ink and one or more spot colour inkjet inks. By using spot colours, such as e.g. the red colour of Coca-Cola™, ink composition can be reduced. Alternatively instead of an inkjet ink set, such as a CMYKW inkjet ink set, printing may also be performed by using only 1, 2 or 3 inkjet inks, such as e.g. a white inkjet ink and a spot colour inkjet ink.
- [0065] The inkjet ink set may also include a varnish, preferably a UV curable varnish. A varnish allows to influence the glossiness of the colour image in a desired way

Colour Pigments

- [0066] The colour inkjet ink preferably contains a colour pigment having an average particle size of no more than 230 nm. Above the average particle size of 230 nm the colour image tends to become opaque. As the colour image becomes opaque, not only the colour gamut is reduced but also the metallic effect is lost.
- [0067] The colour inkjet ink contains at least a colour pigment but may be combined with a dye. Organic and/or inorganic colour pigments may be used.
- [0068] The colour pigments may be black, cyan, magenta, yellow, red, orange, violet, blue, green, brown, mixtures thereof, and the like. This colour pigment may be chosen from those disclosed by **HERBST, Willy, et al.** Industrial Organic Pigments, Production, Properties, Applications. 3rd edition. Wiley - VCH, 2004. ISBN 3527305769.

- [0069] Particular preferred pigments are C.I. Pigment Yellow 1, 3, 10, 12, 13, 14, 17, 55, 65, 73, 74, 75, 83, 93, 97, 109, 111, 120, 128, 138, 139, 150, 151, 154, 155, 175, 180, 181, 185, 194 and 213. In a particularly preferred embodiment of the inkjet printing method, the yellow pigment is selected from the group consisting of C.I. Pigment Yellow 150, C.I. Pigment Yellow 155, C.I. Pigment Yellow 180, and C.I. Pigment Yellow 213.
- [0070] Particular preferred pigments are C.I. Pigment Red 17, 22, 23, 41, 48:1, 48:2, 49:1, 49:2, 52:1, 57:1, 88, 112, 122, 144, 146, 149, 170, 175, 176, 184, 185, 188, 202, 206, 207, 210, 216, 221, 248, 251, 254, 255, 264, 266, 270 and 272.
- [0071] Particular preferred pigments are C.I. Pigment Violet 19, 23, 32, and 37.
- [0072] Particular preferred pigments are C.I. Pigment Blue 15:1, 15:2, 15:3, 15:4, 15:6, 16, 56, 61 and (bridged) aluminium phthalocyanine pigments.
- [0073] Particular preferred pigments are C.I. Pigment Orange 5, 13, 16, 34, 40, 43, 59, 66, 67, 69, 71 and 73.
- [0074] Particular preferred pigments are C.I. Pigment Green 7 and 36.
- [0075] Particular preferred pigments are C.I. Pigment Brown 6 and 7.
- [0076] Suitable pigments include mixed crystals of the above particular preferred pigments. Mixed crystals are also referred to as solid solutions. For example, under certain conditions different quinacridones mix with each other to form solid solutions, which are quite different from both physical mixtures of the compounds and from the compounds themselves. In a solid solution, the molecules of the components enter into the same crystal lattice, usually, but not always, that of one of the components. The x-ray diffraction pattern of the resulting crystalline solid is characteristic of that solid and can be clearly differentiated from the pattern of a physical mixture of the same components in the same proportion. In such physical mixtures, the x-ray pattern of each of the components can be distinguished, and the disappearance of several of these lines is one of the criteria of the formation of solid solutions. Particularly preferred commercially available mixed crystals include Cinquasia™ Magenta RT-355-D and Cinquasia™ Magenta D 4500 J, from BASF.

- [0077] Carbon black is preferred as a black pigment. Suitable black pigments include carbon blacks such as Pigment Black 7 (e.g. Carbon Black MA8® from MITSUBISHI CHEMICAL), Regal® 400R, Mogul® L, Elftex® 320 from CABOT Co., or Carbon Black FW18, Special Black 250, Special Black 350, Special Black 550, Printex® 25, Printex® 35, Printex® 55, Printex® 90, Printex® 150T from DEGUSSA. In a preferred embodiment, the carbon black pigment used is a pigment having less than 0.15% of toluene-extractable fraction using the method as described in section III, paragraph 5 of the Resolution AP(89) 1 dated 13 September 1989 published by the Council of Europe.
- [0078] It is also possible to make mixtures of pigments. In a preferred embodiment, the black inkjet ink is a neutral black inkjet ink. This neutral black inkjet ink preferably obtained by mixing a black pigment and a cyan pigment into the ink, optionally also a magenta pigment into the ink.
- [0079] Also non-organic pigments may be present in the inks. Suitable pigments are C.I. Pigment Metal 1, 2 and 3. Illustrative examples of the inorganic pigments include yellow lead, zinc yellow, red iron oxide (III), cadmium red, ultramarine blue, prussian blue, chromium oxide green, cobalt green, amber, titanium black and synthetic iron black. However, care should be taken to prevent migration and extraction of heavy metals in case of food packaging application. In the preferred embodiment no pigments are used which contain a heavy metal selected from the group consisting of arsenic, lead, mercury and cadmium. In a more preferred embodiment, no inorganic pigments are used in the inkjet inks with the exception of titanium oxide and calcium carbonate.
- [0080] Pigment particles in inkjet ink should be sufficiently small to permit free flow of the ink through the inkjet-printing device, especially at the ejecting nozzles. It is also desirable to use small particles for maximum colour strength and to slow down sedimentation.
- [0081] The average pigment particle size is preferably between 50 and 230 nm, more preferably between 70 and 200 nm. Most preferably, the average pigment particle size is no larger than 150 nm. An average particle size smaller than 50 nm is less desirable for decreased light-fastness.

[0082] The average pigment particle size of pigment particles is best determined with dynamic light scattering, such as e.g. a PSS-Nicomp™ submicron particle analyzer. Furthermore, this methodology is well-known to the skilled person.

Polymeric Dispersants

[0083] The colour pigment is preferably dispersed using a polymeric dispersant.

[0084] Typical polymeric dispersants are copolymers of two monomers but the polymeric dispersant may contain three, four, five or even more monomers. The properties of polymeric dispersants depend on both the nature of the monomers and their distribution in the polymer. Copolymeric dispersants preferably have the following polymer compositions:

- statistically polymerized monomers (e.g. monomers A and B polymerized into ABBAABAB);
- alternating polymerized monomers (e.g. monomers A and B polymerized into ABABABAB);
- gradient (tapered) polymerized monomers (e.g. monomers A and B polymerized into AAABAABBABBB);
- block copolymers (e.g. monomers A and B polymerized into AAAAABBBBBB) wherein the block length of each of the blocks (2, 3, 4, 5 or even more) is important for the dispersion capability of the polymeric dispersant;
- graft copolymers (graft copolymers consist of a polymeric backbone with polymeric side chains attached to the backbone); and
- mixed forms of these polymers, e.g. blocky gradient copolymers.

[0085] Suitable polymeric dispersants are listed in the section on “Dispersants”, more specifically [0064] to [0070] and [0074] to [0077], in **EP 1911814 A** (AGFA GRAPHICS) incorporated herein as a specific reference.

[0086] The polymeric dispersant has preferably a number average molecular weight M_n between 500 and 30,000, more preferably between 10,000 and 25,000.

[0087] The polymeric dispersant has preferably a weight average molecular weight M_w smaller than 100,000, more preferably smaller than 70,000.

- [0088] The polymeric dispersant has preferably a polydispersity PD smaller than 2, more preferably smaller than 1.75 and most preferably smaller than 1.5.
- [0089] Commercial examples of polymeric dispersants are the following:
- DISPERBYK™ dispersants available from BYK CHEMIE GMBH;
 - SOLSPERSE™ dispersants available from LUBRIZOL;
 - TEGO™ DISPERS™ dispersants from EVONIK;
 - EDAPLAN™ dispersants from MÜNZING CHEMIE;
 - ETHACRYL™ dispersants from LYONDELL;
 - GANEX™ dispersants from ISP;
 - DISPEX™ and EFKA™ dispersants from BASF;
 - DISPONER™ dispersants from DEUCHEM.
- [0090] Particularly preferred polymeric dispersants include Solsperse™ dispersants from LUBRIZOL, Efka™ dispersants from BASF and Disperbyk™ dispersants from BYK CHEMIE GMBH. Particularly preferred dispersants are Solsperse™ 32000, 35000 and 39000 dispersants from LUBRIZOL.
- [0091] The polymeric dispersant is preferably used in an amount of 2 to 600 wt%, more preferably 5 to 200 wt%, most preferably 50 to 90 wt% based on the weight of the pigment.

Photoinitiators

- [0092] The UV curable inkjet ink contains at least one photoinitiator, but may contain a photoinitiating system including a plurality of photoinitiators and/or co-initiators.
- [0093] The photoinitiator is preferably a free radical initiator, more specifically a Norrish type I initiator or a Norrish type II initiator. A free radical photoinitiator is a chemical compound that initiates polymerization of monomers and oligomers when exposed to actinic radiation by the formation of a free radical. A Norrish Type I initiator is an initiator which cleaves after excitation, yielding the initiating radical immediately. A Norrish type II-initiator is a photoinitiator which is activated by actinic radiation and forms free radicals by hydrogen abstraction from a second compound that becomes the actual initiating free radical. This second compound is called a polymerization synergist or co-initiator. Both type I

and type II photoinitiators can be used in the present invention, alone or in combination.

- [0094] Suitable photoinitiators are disclosed in **CRIVELLO, J.V., et al.** Photoinitiators for Free Radical Cationic and Anionic Photopolymerization. 2nd edition. Edited by BRADLEY, G.. London, UK: John Wiley and Sons Ltd, 1998. p.287-294.
- [0095] Specific examples of photoinitiators may include, but are not limited to, the following compounds or combinations thereof: benzophenone and substituted benzophenones, 1-hydroxycyclohexyl phenyl ketone, thioxanthenes such as isopropylthioxanthone, 2-hydroxy-2-methyl-1-phenylpropan-1-one, 2-benzyl-2-dimethylamino- (4-morpholinophenyl) butan-1-one, benzil dimethylketal, bis (2,6- dimethylbenzoyl)-2,4,4-trimethylpentylphosphine oxide, 2,4,6 trimethylbenzoyldiphenylphosphine oxide, 2,4,6-trimethoxybenzoyldiphenylphosphine oxide, 2-methyl-1- [4-(methylthio) phenyl] -2-morpholinopropan-1-one, 2,2-dimethoxy-1, 2-diphenylethan-1-one or 5,7-diiodo-3- butoxy-6-fluorone.
- [0096] Suitable commercial photoinitiators include Irgacure™ 184, Irgacure™ 500, Irgacure™ 369, Irgacure™ 1700, Irgacure™ 651, Irgacure™ 819, Irgacure™ 1000, Irgacure™ 1300, Irgacure™ 1870, Darocur™ 1173, Darocur™ 2959, Darocur™ 4265 and Darocur™ ITX available from CIBA SPECIALTY CHEMICALS, Lucerin™ TPO available from BASF AG, Esacure™ KT046, Esacure™ KIP150, Esacure™ KT37 and Esacure™ EDB available from LAMBERTI, H-Nu™ 470 and H-Nu™ 470X available from SPECTRA GROUP Ltd..
- [0097] For food packaging applications, so-called UV curable low migration inkjet inks are used wherein the photoinitiator is preferably a so-called diffusion hindered photoinitiator. A diffusion hindered photoinitiator is a photoinitiator which exhibits a much lower mobility in a cured layer of the ink than a monofunctional photoinitiator, such as benzophenone. Several methods can be used to lower the mobility of the photoinitiator. One way is to increase the molecular weight of the photoinitiators so that the diffusion speed is reduced, e.g. polymeric photoinitiators. Another way is to increase its reactivity so that it is built into the polymerizing network, e.g.

multifunctional photoinitiators (having 2, 3 or more photoinitiating groups) and polymerizable photoinitiators.

- [0098] The diffusion hindered photoinitiator is preferably selected from the group consisting of non-polymeric multifunctional photoinitiators, oligomeric or polymeric photoinitiators and polymerizable photoinitiators. Non-polymeric di- or multifunctional photoinitiators are considered to have a molecular weight between 300 and 900 Dalton. Non-polymerizable monofunctional photoinitiators with a molecular weight in that range are not diffusion hindered photoinitiators. Most preferably the diffusion hindered photoinitiator is a polymerizable initiator or a polymeric photoinitiator.
- [0099] Another advantage of using one or more diffusion hindered photoinitiators is the resulting low odour after UV curing. This is advantageously used in e.g. luxury packaging including a metallic decoration for perfumes, wine, beer labels, cosmetics, cigarettes, razorblades, toothpaste and the like.
- [0100] A preferred diffusion hindered photoinitiator contains one or more photoinitiating functional groups derived from a Norrish type I-photoinitiator selected from the group consisting of benzoinethers, benzil ketals, α,α -dialkoxyacetophenones, α -hydroxyalkylphenones, α -aminoalkylphenones, acylphosphine oxides, acylphosphine sulphides, α -haloketones, α -halosulfones and phenylglyoxalates.
- [0101] A preferred diffusion hindered photoinitiator contains one or more photoinitiating functional groups derived from a Norrish type II-initiator selected from the group consisting of benzophenones, thioxanthenes, 1,2-diketones and anthraquinones.
- [0102] Suitable diffusion hindered photoinitiators are also those disclosed in **EP 2065362 A** (AGFA) in paragraphs [0074] and [0075] for difunctional and multifunctional photoinitiators, in paragraphs [0077] to [0080] for polymeric photoinitiators and in paragraphs [0081] to [0083] for polymerizable photoinitiators.
- [0103] Other preferred polymerizable photoinitiators are those disclosed in **EP 2161264 A** (AGFA) . A preferred amount of photoinitiator is 0 - 50 wt%, more preferably 0.1 - 20 wt%, and most preferably 0.3 – 15 wt% of the total weight of the UV curable inkjet ink.

- [0104] In a very preferred embodiment, the UV curable inkjet ink includes a polymerizable or polymeric thioxanthone photoinitiator and an acylphosphine oxide-based polymerization photoinitiator, more preferably a bis(2,4,6-trimethylbenzoyl)-phenylphosphineoxide photoinitiator.
- [0105] Photoinitiators like bis(2,4,6-trimethylbenzoyl)-phenylphosphineoxide photoinitiator are monofunctional but are allowed by the Swiss ordinance SR 817.023.21 on Objects and Materials due to their very low toxicity level.
- [0106] In order to increase the photosensitivity further, the UV curable inkjet ink may additionally contain co-initiators. Suitable examples of co-initiators can be categorized in three groups: 1) tertiary aliphatic amines such as methyldiethanolamine, dimethylethanolamine, triethanolamine, triethylamine and N-methylmorpholine; (2) aromatic amines such as amylparadimethylaminobenzoate, 2-n-butoxyethyl-4-(dimethylamino)benzoate, 2-(dimethylamino)ethylbenzoate, ethyl-4-(dimethylamino)benzoate, and 2-ethylhexyl-4-(dimethylamino)benzoate; and (3) (meth)acrylated amines such as dialkylamino alkyl(meth)acrylates (e.g., diethylaminoethylacrylate) or N-morpholinoalkyl-(meth)acrylates (e.g., N-morpholinoethyl-acrylate). The preferred co-initiators are aminobenzoates.
- [0107] When one or more co-initiators are included into the UV curable inkjet ink, preferably these co-initiators are diffusion hindered for safety reasons.
- [0108] A diffusion hindered co-initiator is preferably selected from the group consisting of non-polymeric di- or multifunctional co-initiators, oligomeric or polymeric co-initiators and polymerizable co-initiators. More preferably the diffusion hindered co-initiator is selected from the group consisting of polymeric co-initiators and polymerizable co-initiators. Most preferably the diffusion hindered co-initiator is a polymerizable co-initiator having at least one (meth)acrylate group, more preferably having at least one acrylate group.
- [0109] The UV curable inkjet ink preferably includes a polymerizable or polymeric tertiary amine co-initiator.

- [0110] Preferred diffusion hindered co-initiators are the polymerizable co-initiators disclosed in **EP 2053101 A** (AGFA) in paragraphs [0088] and [0097].
- [0111] Preferred diffusion hindered co-initiators include a polymeric co-initiator having a dendritic polymeric architecture, more preferably a hyperbranched polymeric architecture. Preferred hyperbranched polymeric co-initiators are those disclosed in **US 2006014848 A** (AGFA) .
- [0112] The UV curable inkjet ink preferably includes the (diffusion hindered) co-initiator in an amount of 0.1 to 50 wt%, more preferably in an amount of 0.5 to 25 wt%, most preferably in an amount of 1 to 15 wt% of the total weight of the UV curable inkjet ink.

Polymerizable Compounds

- [0113] The polymerizable compounds are preferably monomers and/or oligomers.
- [0114] The monomers and oligomers used in UV curable inkjet inks, especially for food packaging applications, are preferably purified compounds having no or almost no impurities, more particularly no toxic or carcinogenic impurities. The impurities are usually derivative compounds obtained during synthesis of the polymerizable compound. Sometimes, however, some compounds may be added deliberately to pure polymerizable compounds in harmless amounts, for example, polymerization inhibitors or stabilizers.
- [0115] Any monomer or oligomer capable of free radical polymerization may be used as polymerizable compound. A combination of monomers, oligomers and/or prepolymers may also be used. The monomers, oligomers and/or prepolymers may possess different degrees of functionality, and a mixture including combinations of mono-, di-, tri- and higher functionality monomers, oligomers and/or prepolymers may be used. The viscosity of the UV curable inks can be adjusted by varying the ratio between the monomers and oligomers.
- [0116] Particularly preferred monomers and oligomers are those listed in [0106] to [0115] in **EP 1911814 A** (AGFA) .

Polymerization Inhibitors

- [0117] The radiation curable inkjet ink may contain a polymerization inhibitor. Suitable polymerization inhibitors include phenol type antioxidants,

hindered amine light stabilizers, phosphor type antioxidants, hydroquinone monomethyl ether commonly used in (meth)acrylate monomers, and hydroquinone, t-butylcatechol, pyrogallol may also be used.

- [0118] Suitable commercial inhibitors are, for example, Sumilizer™ GA-80, Sumilizer™ GM and Sumilizer™ GS produced by Sumitomo Chemical Co. Ltd.; Genorad™ 16, Genorad™ 18 and Genorad™ 20 from Rahn AG; Irgastab™ UV10 and Irgastab™ UV22, Tinuvin™ 460 and CGS20 from BASF; Floorstab™ UV range (UV-1, UV-2, UV-5 and UV-8) from Kromachem Ltd, Additol™ S range (S100, S110, S120 and S130) from Cytec Surface Specialties.
- [0119] Since excessive addition of these polymerization inhibitors will lower the ink sensitivity to curing, it is preferred that the amount capable of preventing polymerization is determined prior to blending. The amount of a polymerization inhibitor is preferably lower than 2 wt% of the total inkjet ink.
- [0120] In a preferred embodiment, the polymerization inhibitor is a polymerizable inhibitor, preferably containing one or more acrylate groups for achieving good reactivity.

Surfactants

- [0121] The UV curable inkjet ink may contain at least one surfactant. The surfactant can be anionic, cationic, non-ionic, or zwitter-ionic and is preferably added in a total quantity less than 3 wt% based on the total weight of the ink and particularly in a total less than 1wt% based on the total weight of the UV curable inkjet ink.
- [0122] Preferred surfactants are selected from fluoro surfactants (such as fluorinated hydrocarbons) and silicone surfactants. The silicone surfactants are preferably siloxanes and can be alkoxylated, polyester modified, polyether modified, polyether modified hydroxy functional, amine modified, epoxy modified and other modifications or combinations thereof. Preferred siloxanes are polymeric, for example polydimethylsiloxanes.
- [0123] Preferred commercial silicone surfactants include BYK™ 333 and BYK™ UV3510 from BYK Chemie.
- [0124] In a preferred embodiment, the surfactant is a polymerizable compound.

- [0125] Preferred polymerizable silicone surfactants include a (meth)acrylated silicone surfactant. Most preferably the (meth)acrylated silicone surfactant is an acrylated silicone surfactant, because acrylates are more reactive than methacrylates.
- [0126] In a preferred embodiment, the (meth)acrylated silicone surfactant is a polyether modified (meth)acrylated polydimethylsiloxane or a polyester modified (meth)acrylated polydimethylsiloxane.
- [0127] Preferred commercially available (meth)acrylated silicone surfactants include: Ebecryl™ 350, a silicone diacrylate from Cytec; the polyether modified acrylated polydimethylsiloxane BYK™ UV3500 and BYK™ UV3530, the polyester modified acrylated polydimethylsiloxane BYK™ UV3570, all manufactured by BYK Chemie; Tego™ Rad 2100, Tego™ Rad 2200N, Tego™ Rad 2250N, Tego™ Rad 2300, Tego™ Rad 2500, Tego™ Rad 2600, and Tego™ Rad 2700, Tego™ RC711 from EVONIK; Silaplane™ FM7711, Silaplane™ FM7721, Silaplane™ FM7731, Silaplane™ FM0711, Silaplane™ FM0721, Silaplane™ FM0725, Silaplane™ TM0701, Silaplane™ TM0701T all manufactured by Chisso Corporation; and DMS-R05, DMS-R11, DMS-R18, DMS-R22, DMS-R31, DMS-U21, DBE-U22, SIB1400, RMS-044, RMS-033, RMS-083, UMS-182, UMS-992, UCS-052, RTT-1011 and UTT-1012 all manufactured by Gelest, Inc..

Ink Receivers

- [0128] There is no real limitation on the type of ink receiver. The ink receiver may have ceramic, metallic, wood, leather, paper or polymeric surfaces for printing. The ink receiver may also be primed.
- [0129] However, the advantages of the UV curable compositions and inkjet of the invention can be especially advantageously used on ink receivers for (food)packaging, cosmetics, perfumes, toothpaste and pharmaceuticals. Food packaging is understood to include also packaging for liquids and drinks like milk, water, coke, beer, vegetable oil and the like.
- [0130] The invention is advantageously used for providing so-called "primary" food packaging. Primary food packaging is the material that first envelops the product and holds it. This usually is the smallest unit of distribution or

use and is the package which is in direct contact with the contents. Secondary packaging is outside the primary packaging is used to group primary packages together. Tertiary packaging is used for bulk handling, warehouse storage and transport shipping. The most common form of tertiary packaging is a palletized unit load that packs tightly into containers. A colour image including a metallic or pearlescent colour produced according to the present invention on (primary) packaging has the advantage that it make products stand out on the shelf. Such effect can be enhanced by using a transparent ink receiver that allows to view the content of the packaging, and this by using a single ink receiver as packaging material and avoiding multiple packaging materials and glue as required by state-of-the-art packaging.

- [0131] The substrate may be porous, as e.g. textile, paper and card board substrates, or substantially non-absorbing substrates such as e.g. a plastic substrate having a polyethylene terephthalate surface.
- [0132] Preferred substrates including surfaces of polyethylene, polypropylene, polycarbonate, polyurethane, polyvinyl chloride, polyesters like polyethylene terephthalate (PET), polyethylene naphthalate (PEN) and polylactide (PLA), polyimide, copolymers thereof and blends thereof.
- [0133] The substrate may also be a paper substrate, such as plain paper or resin coated paper, e.g. polyethylene or polypropylene coated paper. There is no real limitation on the type of paper and it includes newsprint paper, magazine paper, office paper, wallpaper but also paper of higher grammage, usually referred to as boards, such as white lined chipboard, corrugated board and packaging board.
- [0134] The substrates may be transparent, translucent or opaque. Preferred opaque substrates includes so-called synthetic paper, like the Synaps™ grades from Agfa-Gevaert which are an opaque polyethylene terephthalate sheet having a density of 1.10 g/cm³ or more.
- [0135] In a preferred embodiment of the inkjet printing method, the ink receiver is a transparent substrate.
- [0136] There is no restriction on the shape of the substrate. It can be a flat sheet, such a paper sheet or a polymeric film or it can be a three dimensional

object like e.g. a plastic coffee cup. The three dimensional object can also be a container like a bottle or a jerry-can for including e.g. oil, shampoo, insecticides, pesticides, solvents, paint thinner or other type of liquids.

Colour Images

- [0137] A colour image printed by an inkjet printing method according to any one of claims 1 to 11.
- [0138] The colour image according to claim 12, printed on a packaging material as ink receiver.
- [0139] The colour image according to claim 13, wherein the packaging material is a packaging material for food packaging and the colour image includes one or more compounds selected from the group consisting of a polymerizable photoinitiator, a polymeric photoinitiator and a polymerizable compound including at least a vinyl ether group and an acrylate group.

Inkjet Printing Devices

- [0140] The inkjet inks may be jetted by one or more print heads ejecting small droplets in a controlled manner through nozzles onto a substrate, which is moving relative to the print head(s).
- [0141] A preferred print head for the inkjet printing system is a piezoelectric head. Piezoelectric inkjet printing is based on the movement of a piezoelectric ceramic transducer when a voltage is applied thereto. The application of a voltage changes the shape of the piezoelectric ceramic transducer in the print head creating a void, which is then filled with ink. When the voltage is again removed, the ceramic expands to its original shape, ejecting a drop of ink from the print head. However the inkjet printing method according to the present invention is not restricted to piezoelectric inkjet printing. Other inkjet print heads can be used and include various types, such as a continuous type.
- [0142] The inkjet print head normally scans back and forth in a transversal direction across the moving ink-receiver surface. Often the inkjet print head does not print on the way back. Bi-directional printing, also known as multi-pass printing, is preferred for obtaining a high areal throughput. Another preferred printing method is by a "single pass printing process", which can be performed by using page wide inkjet print heads or multiple

staggered inkjet print heads which cover the entire width of the ink-receiver surface. In a single pass printing process the inkjet print heads usually remain stationary and the substrate surface is transported under the inkjet print heads.

Curing Devices

- [0143] The radiation curable inkjet ink can be cured by electron beam or UV light. Preferably the radiation curable inkjet ink is a UV curable inkjet ink, which is preferably cured by exposure to ultraviolet radiation, most preferably coming exclusively from UV LEDs. The curing device may be arranged in combination with the print head of the inkjet printer, travelling therewith so that the curing radiation is applied very shortly after jetting. Such rapid curing is sometimes referred to as "pin curing" and used for enhancing image quality by controlling the dot size. Preferably such curing means consists of one or more UV LEDs. In such an arrangement, it can be difficult to provide other types of curing means that are small enough to be connected to and travelling with the print head. Therefore, a static fixed radiation source may be employed, e.g. a source of curing UV-light, connected to the radiation source by means of flexible radiation conductive means such as a fibre optic bundle or an internally reflective flexible tube. Alternatively, the actinic radiation may be supplied from a fixed source to the radiation head by an arrangement of mirrors including a mirror upon the print head.
- [0144] The source of radiation may also be an elongated radiation source extending transversely across the substrate to be cured. It may be adjacent the transverse path of the print head so that the subsequent rows of images formed by the print head are passed, stepwise or continually, beneath that radiation source.
- [0145] Any ultraviolet light source, as long as part of the emitted light can be absorbed by the photo-initiator or photo-initiator system, may be employed as a radiation source, such as a high or low pressure mercury lamp, a cold cathode tube, a black light, an ultraviolet LED, an ultraviolet laser, and a flash light. Of these, the preferred source is one exhibiting a relatively long wavelength UV-contribution having a dominant wavelength of 300-400 nm.

Specifically, a UV-A light source is preferred due to the reduced light scattering therewith resulting in more efficient interior curing.

[0146] UV radiation is generally classed as UV-A, UV-B, and UV-C as follows:

- UV-A: 400 nm to 320 nm
- UV-B: 320 nm to 290 nm
- UV-C: 290 nm to 100 nm.

[0147] In a preferred embodiment, the inkjet printing device contains one or more UV LEDs with a wavelength larger than 360 nm, preferably one or more UV LEDs with a wavelength larger than 380 nm, and most preferably UV LEDs with a wavelength of about 395 nm.

[0148] Furthermore, it is possible to cure the image using, consecutively or simultaneously, two light sources of differing wavelength or illuminance. For example, the first UV-source can be selected to be rich in UV-C, in particular in the range of 260 nm-200 nm. The second UV-source can then be rich in UV-A, e.g. a gallium-doped lamp, or a different lamp high in both UV-A and UV-B. The use of two UV-sources has been found to have advantages e.g. a fast curing speed and a high curing degree.

[0149] For facilitating curing, the inkjet printing device often includes one or more oxygen depletion units. The oxygen depletion units place a blanket of nitrogen or other relatively inert gas (e.g. CO₂), with adjustable position and adjustable inert gas concentration, in order to reduce the oxygen concentration in the curing environment. Residual oxygen levels are usually maintained as low as 200 ppm, but are generally in the range of 200 ppm to 1200 ppm.

EXAMPLES

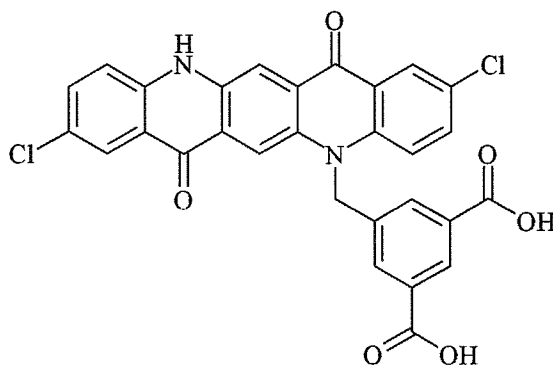
Materials

[0150] All materials used in the following examples were readily available from standard sources such as Sigma-Aldrich (Belgium) and Acros (Belgium) unless otherwise specified

[0151] **PBL7** is Special Black™ 550, a carbon black available from DEGUSSA.

[0152] **PM** is Cinquasia™ Magenta D 4500 J, a mixed crystal quinacridone pigment from BASF.

- [0153] **PB15:4** is an abbreviation used for Hostaperm™ Blue P-BFS, a C.I. Pigment Blue 15:4 pigment from CLARIANT.
- [0154] **PY150** is an abbreviation used for Chromophthal™ Yellow LA2, a C.I. Pigment Yellow 150 from BASF.
- [0155] **TR52** is TIOXIDE TR 52™, a surface modified titanium dioxide from HUNTSMAN CHEMICAL GROUP.
- [0156] **S35000** is an abbreviation for SOLSPERSE™ 35000, a polyethyleneimine-polyester hyperdispersant from NOVEON.
- [0157] **DB162** is an abbreviation used for the polymeric dispersant Disperbyk™ 162 available from BYK CHEMIE GMBH whereof the solvent mixture of 2-methoxy-1-methylethylacetate, xylene and n-butylacetate was removed.
- [0158] **Genorad™ 16** is polymerization inhibitor from RAHN AG.
- [0159] **QAD** is a quinacridone derivative represented by the formula:



QAD.

The dispersion synergist QAD was synthesized according to the method disclosed in paragraph 252 of **WO 2007/060254** (AGFA) .

- [0160] **DPGDA** is dipropyleneglycoldiacrylate available under the trade name of Sartomer™ SR508 from SARTOMER.
- [0161] **PG400DA** is polyethyleneglycol 400 diacrylate available as Sartomer™ SR344 from SARTOMER.
- [0162] **15EO-TMPTA** is an ethoxylated trimethylolpropane triacrylate containing fifteen ethoxy units having a molecular weight of 956 and available as Sartomer™ SR9035 from SARTOMER.
- [0163] **IDA is isodecyl acrylate** available as Sartomer™ SR395 from SARTOMER.

- [0164] **TMPTA** is trimethylolpropane triacrylate available as MIRAMER™ M300 from RAHN.
- [0165] **VEEA** is 2-(2-vinyloxyethoxy)ethyl acrylate, a difunctional monomer available from Nippon Shokubai, Japan.
- [0166] **Darocur™ ITX** is a thioxanthone photo-initiator available from BASF.
- [0167] **Irgacure™ 379** is a photo-initiator available from BASF.
- [0168] **Irgacure™ 907** is a photo-initiator available from BASF.
- [0169] **Esacure™ KTO** is a photoinitiator mixture of trimethylbenzoyl diphenylphosphine oxide, alfa-hydroxyketone en benzophenone derivatives available from FRATELLI LAMBERTI SPA.
- [0170] **TPO** is 2,4,6-trimethylbenzoyl-diphenyl-phosphineoxide available under the trade name Darocur™ TPO from BASF.
- [0171] **Genocure™ EPD** is ethyl 4-dimethylaminobenzoate available from RAHN AG.
- [0172] **BYK™ UV3510** is a polyether modified polydimethylsiloxane wetting agent available from BYK CHEMIE GMBH.
- [0173] **Ebecryl™ 136** is a silicone hexa-acrylate material from ALLNEX.
- [0174] **PMMA** is a transparent polymethylmethacrylate ink receiver for which BARLO™ XT from ANTALIS, Belgium and manufactured by BARLO, Germany was used.
- [0175] **Ultrastar™ FX-1504 Silver** is a solvent based flexo ink containing a metallic pigment listed to have an average particle size of 6 µm available from ECKART GMBH.

Measurement Methods

1. Average Particle Size Colour Inkjet Ink

- [0176] The average particle size of pigment particles was determined with a PSS-Nicomp 380 Submicron Particle Analyzer based upon the principle of dynamic light scattering. The ink or dispersion was diluted with a suitable solvent to a pigment concentration of 0.002 wt%. For the UV curable colour inkjet ink, the solvent used for dilution to a pigment concentration of 0.002 wt% was ethyl acetate.

2. Average Particle Size White Inkjet Ink

[0177] For white inkjet inks, the determination of the average particle diameter was performed by differential centrifugal sedimentation. The measurement was performed with a CPS24000 from CPS Instruments, Inc. Stuart, FL (USA). The analyzer measures particle size distributions using centrifugal sedimentation within an optically clear spinning disc that is filled with a suitable fluid. Sedimentation is stabilized by a density gradient within the fluid, and accuracy of measured sizes is insured through the use of a known size calibration standard before each test. The concentration of particles at each size is determined by continuously measuring the turbidity of the fluid near the outside edge of the rotating disc. The turbidity measurements, in function of analysis time, are converted to a weight distribution using Mie Theory light scattering calculations. The gradient used for the UV curable white inkjet ink was 12ml 85-15%/60-40% t-butylacetate /di-butylphthalate. Samples were diluted by mixing one drop of ink with 20mL t-butylacetate prior to analysis. The speed of rotation was 9000 rpm.

3. Volume Mean Particle Size of Metallic/Pearlescent Pigments

[0178] The particle size distribution was determined in the range of 0.04 to 2000 μm by laser diffraction using a Coulter™ LS230 with PIDS assembly. A sample was first diluted to 1% using a suitable diluent, e.g. one of the liquids present in the sample. For example, water respectively isopropanol may be used for water based respectively solvent based dispersions of metallic or pearlescent pigments. The diluted sample was added to the small volume module, filled with the diluent, until the parameter obscuration obtained a value between 45 and 55%. Once this was achieved, three consecutive measurements were made. The volume mean particle size is the average of the three values of the volume mean particle size determined in each of the three measurements.

4. Viscosity

[0179] The viscosity of the formulations was measured at 45°C using a Haake Rotovisco rheometer with sensor C60/1 Ti. An aliquot of 1.5 mL was used and analyzed at a shear rate of 1,000 s^{-1} . For inkjet printing, a viscosity of

less than 20 mPa.s at 45°C is preferred, more preferably the viscosity was less than 15 mPa.s.

5. Surface tension

[0180] The surface tension of the inkjet inks was measured with a KRÜSS tensiometer K9 at 25°C after 60 seconds. The surface tension of the is preferably from 20 to 50 mN/m at 25°C, more preferably from 22 to 35 mN/m at 25°C. It is preferably 20 mN/m or more from the viewpoint of printability by a second inkjet ink, and it is preferably not more than 35 mN/m from the viewpoint of the wettability.

EXAMPLE 1

[0181] This example illustrates how thin silver and gold coloured lines can be obtained by the inkjet printing method according to the present invention.

Preparation of Concentrated Colour Pigment Dispersions

[0182] The concentrated pigment dispersions KD, MD, CD and YD were all prepared in the same manner except that different types and amounts of pigments, polymeric dispersants and other components were used according to Table 1. The preparation of the concentrated pigment dispersion is exemplified for the concentrated pigment dispersion CD, which was used to prepare the cyan inkjet ink C1.

[0183]

Table 1

wt% of	KD	MD	CD	YD
PB7	11.03	---	---	---
PM	---	15.00	---	---
QAD	---	0.80	---	---
PB15:4	3.97	---	15.00	---
PY150	---	---	---	15.00
S35000	15.00	15.00	15.00	15.00
Genorad™ 16	1.00	1.00	1.00	1.00
DPGDA	69.00	68.20	69.00	69.00
Used in ink:	K1	M1	C1	Y1

[0184] The concentrated pigment dispersion CD was made by mixing 100.0 g of the pigment PB15:4, 6.7 g of Genorad™ 16 and 333.3 g of a 30% solution

in DPGDA™ of the polymeric dispersant S35000 in DPGDA for 30 minutes using a DISPERLUX™ YELLOW075 (from DISPERLUX S.A.R.L., Luxembourg) and subsequently milling this mixture in a Eiger Lab Bead mill (from EIGER TORRANCE Ltd.) using yttrium-stabilized zirconium oxide-beads of 0.4 mm diameter ("high wear resistant zirconia grinding media" from TOSOH Co.). The bead mill is filled for 50% with the grinding beads and water-cooled during milling at 4250 rpm for 180 minutes. After milling the dispersion was separated from the beads using a filter cloth.

Preparation of Concentrated White Pigment Dispersion WD

[0185] A concentrated white pigment dispersion WD was prepared having a composition according to Table 2.

[0186]

Table 2

wt% of :	W1
TR52	50.00
DB162	10.00
Genorad™ 16	1.00
VEEA	39.00

[0187] The concentrated pigment dispersion WD was made by mixing 3.1 kg of VEEA, 28.5 kg of the white pigment TR52, 0.380 kg of the inhibitor Genorad™ 16 and 19.0 kg of a 30% solution of the polymeric dispersant DB162 in VEEA for 30 minutes in a 60 L vessel equipped with a DISPERLUX™ disperser (from DISPERLUX S.A.R.L., Luxembourg). This mixture was subsequently milled in a DYNO™-MILL KD 6 from the company WAB Willy A. Bachofen (Switzerland) using 0.65mm yttrium-stabilized zirconium oxide-beads. The bead mill was filled for 52% with the grinding beads and operated in recirculation mode for 1 hour by using a tip speed of 14.7 m/s. The milling chamber is water-cooled during the operation.

Preparation of Inkjet Ink Set 1

[0188] The concentrated pigment dispersions KD, MD, CD, YD and WD were used to manufacture the inkjet inks K1, M1, C1, Y1, and W1 respectively by mixing them with ingredients according to Table 3.

[0189]

Table 3

in wt% of ink	K1	M1	C1	Y1	W1
DPGDA	48.51	50.35	48.90	47.00	---
PG400DA	15.00	10.00	10.00	10.00	---
15EO-TMPTA	---	5.00	7.50	10.00	---
IDA	15.00	15.00	15.00	15.00	---
TMPTA	---	---	---	---	34.85
VEEA	---	---	---	---	35.90
PB7	2.00	---	---	---	---
PM	---	3.50	---	---	---
QAD	0.01	0.05	---	---	---
PB15:4	0.72	---	3.00	---	---
PY150	---	---	---	2.70	---
TR52	---	---	---	---	17.50
SS35000	3.44	3.50	3.00	2.70	---
DB162	---	---	---	---	3.50
Darocur™ ITX	5.00	5.00	5.00	5.00	---
Irgacure™ 907	5.00	4.00	4.00	4.00	---
Irgacure™ 379	1.00	---	---	---	---
Genocure™ EPD	2.50	2.50	2.50	2.50	---
Esacure™ KTO	---	---	---	---	4.00
TPO	---	---	---	---	2.95
Byk™ UV3510	0.10	0.10	0.10	0.10	---
Ebecryl™ 1360	---	---	---	---	0.30
Genorad™ 16	1.00	1.00	1.00	1.00	1.00

[0190] The physical properties of the inkjet inks were measured and are shown by Table 4.

Table 4

Physical Properties	K1	M1	C1	Y1	W1
Viscosity at 45°C (mPa.s)	9.2	9.9	9.2	9.6	13.5
Surface tension (mN/m)	23.9	24.3	24.6	24.5	22.9

Average particle size (nm)	130	159	153	199	275
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Preparation of Colour Image

- [0191] The volume mean particle size of a solvent based flexo ink Ultrastar™ FX-1504 Silver was determined using laser diffraction and a dilution of 0.5 mL in 50 mL of isopropanol. The volume mean particle size was found to be 11.2 μm .
- [0192] The solvent based flexo ink Ultrastar™ FX-1504 Silver was coated on part of a transparent PMMA ink receiver using a bar coater and a 10 μm wired bar. The partially coated ink receiver was dried at 25°C. After drying, part of the coated ink receiver had a mirror-like silver colour. Samples of the coated and dried ink receiver were used in the following inkjet printing tests wherein the ink set 1 was connected to an Anapurna™ Mw inkjet printer of Agfa Graphics NV. Bidirectional printing was performed in a 4 pass mode at 720x720 dpi with the UV curing lamps at full power.
- [0193] A 3 cm x 4 cm square of the white inkjet ink W1 was printed on an area of the ink receiver coated with the flexo ink Ultrastar™ FX-1504 Silver and on uncoated area. No noticeable difference could be observed between the two areas. The mirror-like silver colour was no longer visible in the area of the ink receiver coated with the flexo ink and printed by the white inkjet ink W1.
- [0194] A colour image consisting of 3 cm x 4 cm squares of cyan, magenta, yellow, black, red, blue and green was inkjet printed on an area of the ink receiver coated with the flexo ink Ultrastar™ FX-1504 Silver, by printing one or more of the colour inkjet inks C1, M1, Y1 and K1. The colour squares exhibited a metallic shine.
- [0195] The same colour image consisting of 3 cm x 4 cm squares of cyan, magenta, yellow, black, red, blue and green was inkjet printed on an area of the ink receiver coated with the flexo ink Ultrastar™ FX-1504 Silver, by printing first a layer of the white inkjet ink W1 and then one or more of the colour inkjet inks C1, M1, Y1 and K1. Bright colours were now observed for the colour squares.
- [0196] Multiple colour images consisting of 3 cm x 4 cm squares of cyan, magenta, yellow, black, red, blue and green were inkjet printed on an area

of the ink receiver coated with the flexo ink Ultrastar™ FX-1504 Silver, by printing first a layer of the white inkjet ink W1 and then one or more of the colour inkjet inks C1, M1, Y1 and K1. The different colour images were separated from each other by thin silver lines having a width 0.5 mm and 1 mm.

[0197] The latter printing mode open possibilities for inkjet printing luxury packaging, for example, a black coffee packaging containing fine silver lines and text. As the printing was performed on only part of a transparent ink receiver, this makes it also possible to show the coffee beans inside the packaging. The capability of inkjet printing variable text on-the-fly, e.g. changing the language of the text, allows for high flexibility and productivity in manufacturing of the packaging material, which can now even be performed using a single transparent ink receiver in-house at the product manufacturer using the packaging material.

[0198] Upon further printing tests surprisingly another advantage was found of the current inkjet printing method. Upon printing the yellow ink Y1 on an area of the ink receiver containing the silver coloured layer of the flexo ink Ultrastar™ FX-1504 Silver, it was found that at a surface coverage between 10% and 45%, a gold colour could be produced. This effect was only possible if the yellow inkjet ink was not an opaque ink, i.e. the average particle size being less than 230 nm. Contrary to e.g. flexographic printing, which requires both the application of both a silver and a gold flexo ink, one of the 4 process colours (CMYK) already present in the inkjet printer, i.e. the yellow inkjet ink, could also be used to produce a gold colour, thereby simplifying the printing process.

Claims

- Claim 1. A method of inkjet printing a colour image including a metallic or pearlescent colour comprising the steps of:
- applying on part of an ink receiver a layer containing a pearlescent or metallic pigment having a volume mean particle size of at least 3.0 μm as measured by laser diffraction; and
 - inkjet printing on part of the layer containing the pearlescent or metallic pigment a layer with a white inkjet ink containing a white pigment having a average particle size between 250 and 400 nm as measured by differential centrifugal sedimentation.
- Claim 2. The method according to claim 1 including a further step of inkjet printing a layer of a colour inkjet ink containing a colour pigment having an average particle size of no more than 230 nm on part of the layer containing a pearlescent or metallic pigment, wherein the average particle size is measured by dynamic light scattering.
- Claim 3. The method according to claim 2, wherein the colour inkjet ink is a yellow inkjet ink applied at a surface coverage between 10% and 45%.
- Claim 4. The method according to claim 1 to 3, wherein the white inkjet ink is a UV curable white inkjet ink.
- Claim 5. The method according to any one of claims 2 to 4, wherein the colour inkjet ink is an UV curable colour inkjet ink.
- Claim 6. The method according to any one of claims 1 to 5, wherein the layer containing a pearlescent or metallic pigment is applied by a method selected from the group consisting of coating techniques, flexographic printing, valve-jet printing, tampon printing, gravure printing, screen printing and offset printing.
- Claim 7. The method according to any one of claims 1 to 6, wherein for inkjet printing the white inkjet ink from one or more print heads having nozzles with a nozzle diameter of no more than 35 μm .
- Claim 8. The method according to any one of claims 1 to 7, wherein the inkjet printing is performed by single pass inkjet printing.
- Claim 9. The method according to any one of claims 1 to 8, wherein the pearlescent or metallic pigment having a volume mean particle size between 5.0 and 50.0 μm .

- Claim 10. The method according to any one of claims 1 to 9, wherein the ink receiver is transparent.
- Claim 11. The method according to any one of claims 1 to 10, wherein the white inkjet ink includes a titanium dioxide pigment.
- Claim 12. The method according to any one of claims 3 to 11, wherein the yellow inkjet ink contains a yellow pigment selected from the group consisting of C.I. Pigment Yellow 150, C.I. Pigment Yellow 155, C.I. Pigment Yellow 180, and C.I. Pigment Yellow 213.
- Claim 13. A printed article containing a colour image printed on an ink receiver by an inkjet printing method according to any one of claims 1 to 12.
- Claim 14. The printed article according to claim 13 selected from the group consisting of a packaging and a foil.
- Claim 15. The printed article according to claim 14, wherein the colour image includes one or more compounds selected from the group consisting of a polymerizable photoinitiator, a polymeric photoinitiator and a polymerizable compound including at least a vinyl ether group and an acrylate group.

INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2015/074957

A. CLASSIFICATION OF SUBJECT MATTER
INV. B41M5/00
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
B41M C09D B41J

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal, CHEM ABS Data, INSPEC, IBM-TDB, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2008/213518 A1 (OYANAGI TAKASHI [JP] ET AL) 4 September 2008 (2008-09-04) paragraph [0002] paragraphs [0010] - [0017] paragraphs [0034] - [0037] paragraphs [0100] - [0102] paragraphs [0223] - [0234] claims 1-22; example 1 -----	1-15
X	US 2009/220695 A1 (OYANAGI TAKASHI [JP] ET AL) 3 September 2009 (2009-09-03) paragraphs [0011] - [0014] paragraphs [0030] - [0033] paragraphs [0072] - [0081] paragraphs [0132] - [0135] paragraphs [0146] - [0148] claims 1, 15, 16 ----- -/-	1-15



Further documents are listed in the continuation of Box C.



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INTERNATIONAL SEARCH REPORT

International application No
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C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
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